

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017054**Date Inspected:** 24-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10, BIKE PATH (HSR1(B)-9343)

During random in process inspection this QA inspector observed that ZPMC personnel performing heat straightening on the weld joints of bike path. The QC monitoring HSR is identified Mr. Li Jun. The members are identified as OBG components and the weld designations reviewed are as follows.

BK004A1-032-009

BK004A-025

BAY 10 BIKE PATH

FCAW welding of weld joint 134 located on BK004A5-029.

Welder is identified as 052075. ZPMC QC is identified as Mr. Ma Qian Li.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

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FCAW welding of weld joint 135 located on BK004A5-029.

Welder is identified as 057180. ZPMC QC is identified as Mr. Ma Qian Li.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint 135 located on BK004A5-030.

Welder is identified as 053116. ZPMC QC is identified as Mr. Ma Qian Li.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

TOWER FACADE SUBASSEMBLY

SMAW welding of weld joint 001 located on ND1-SFSA4-335A/B.

Welder is identified as 040268. ZPMC QC is identified as Mr. Wang Hao.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

SMAW welding of weld joint 002 located on ND1-SFSA4-335A/B.

Welder is identified as 056364. ZPMC QC is identified as Mr. Wang Hao.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

BAY 11 BIKE PATH

SMAW welding of weld joint 134 located on BK004A5-018.

Welder is identified as 040655. ZPMC QC is identified as Mr. Shao Hai Long.

The welding variables recorded by QC appeared to comply with WPS-B-P-2212-B-U2.

FCAW welding of weld joint 008 located on BK004A1-021.

Welder is identified as 053316. ZPMC QC is identified as Mr. Shao Hai Long.

The welding variables recorded by QC appeared to comply with WPS-B-P-2212-B-U2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
